

der ID 159719

April 18, 2017 11:32:54 AM

SPLIT 3

159719

Page 1

D2646

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Cap

Stop *NS2*

Start Date: 4/18/2017 Start Qty: 50.00

Required Date: 5/18/2017 Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

50
50 30

Approvals:

Process Plan:

Date: APR 17 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2646

Rev C

100

100

Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 35991 1-Spin as per Dwg D2646 2-Material release
note required

Vendor: Sieg's Manufacturing

50

APR 18

DAS
13
289

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

1.00

Ensure Material Release Note is attached

50x Sp 17-5-19

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

50

DAS
36
9-85

MAY 19 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Tuesday, April 18, 2017 11:32:54 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/18/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/18/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop ***NR2***

[illegible]

DQA: _____ Date: _____

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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 159719

159719

Page 3

Tuesday, April 18, 2017 11:32:54 AM

Item ID: D2646 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Cap
Start Date: 4/18/2017 Start Qty: 50.00 *50* Cust Item ID:
Required Date: 5/18/2017 Req'd Qty: 50.00 *50* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum <i>M 137176</i> Memo START TIME: <i>8:40</i> FINISH TIME: <i>9:10</i> OVEN TEMPERATURE: <i>300</i>	0.00 0.60				<i>17</i>	<i>0</i>	<i>17-07-14</i>	<i>15 34 9-89</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.50				<i>X9</i>	<i>0</i>	<i>17/07/20</i>	<i>DAS 15 9-89</i>
180 *180* Small Fab Small Fab	Small Fab Memo Install inserts as per Dwg D2646	0.00 0.96				<i>X9</i>	<i>0</i>	<i>17/07/20</i>	

N

JUL 27 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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17/7/31

JUL 12 2017

21 JUL 12 2012
(19) 200 410231
13
8-09

17-07-27

246
21
9-49

JUL 12 2017

Picklist Print

Tuesday, April 18, 2017 11:32:54 AM

Page 1

Work Order ID: 159719

159719

Parent Item: D2646

D2646

Parent Item Name: Aft Cap

Start Date: 4/18/2017

Required Date: 5/18/2017

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: G05.08.22Hole size revised in Step 5KJ/JLM

IPP Rev:H Changed Inserts 07-02-19 JLM

IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130	AELS8-1032-130	Purchased	No			110	Each	2,515.000	2	180			

AI S7-1032-130

Rivnut

**

all 4/18/22

Location

Loc Qty

Loc Code

FG

100

M128649

50

M136048

50

FP001

2207

M128649

155

M136579

2052

ST556

208

M136048

208

D2646P

Purchased

No

180

Each

0.0000

1

50

D2646P

Aft Cap

**

50 x S2175-19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

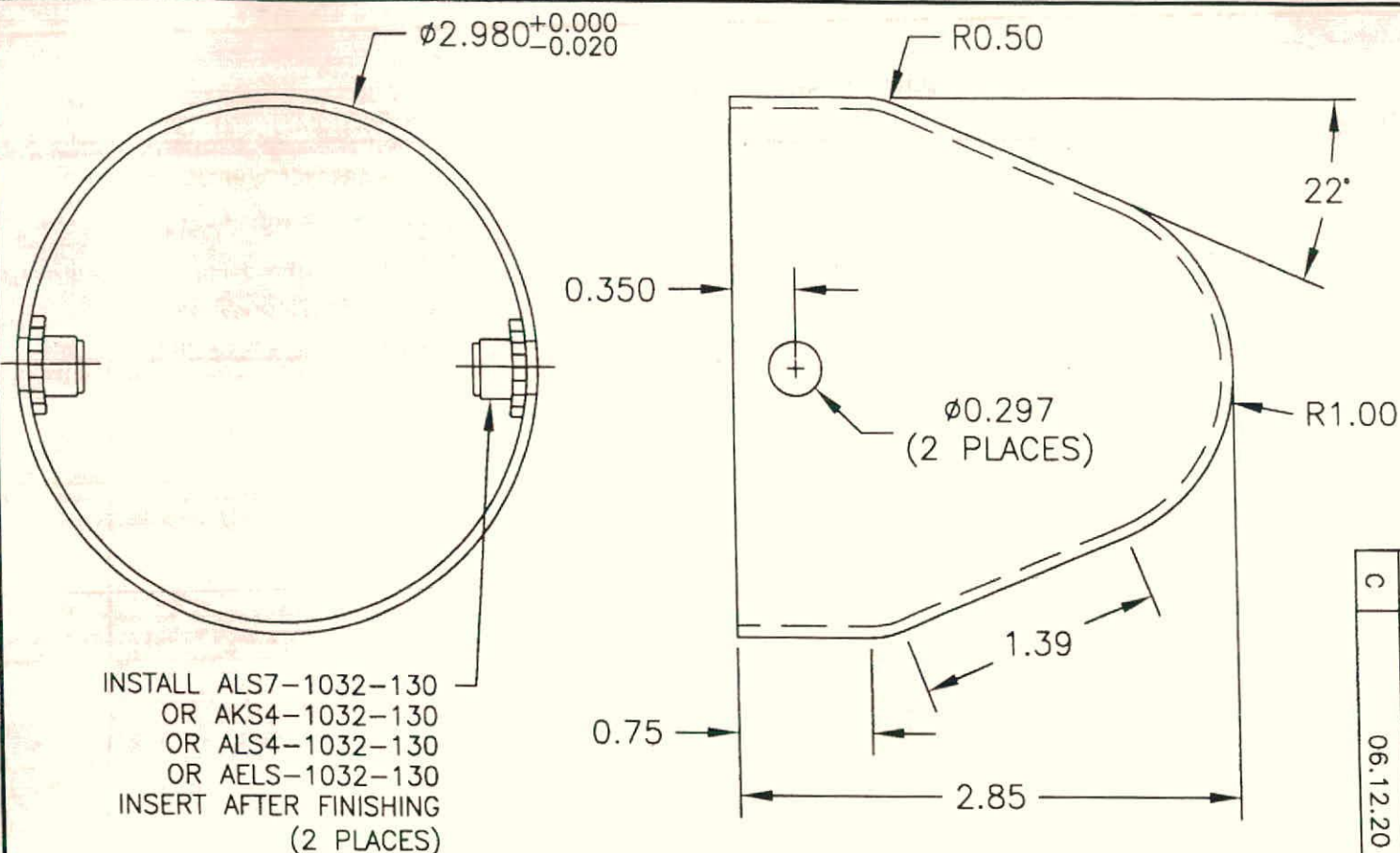
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																						OTHER : _____																																									

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
DATE	06.12.20	TITLE	AFT CAP	D2646	SHEET 1 OF 1
A	97.03.25	SCALE	1:1	CHANGE TO CLOSED INSERTS	
B	05.04.01			CHANGE TO OPEN ENDED INSERTS	
C	06.12.20				



INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

APR 18 1967

W/O: 159719

07.02.12

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Sieg's Manufacturing Ltd.

Quality Metal Spinning

Website: www.siegsnfg.com

6236 205 Street Langley, British Columbia, Canada V2Y 1N7

Phone: (604) 530-7455 ~Email: accounts@siegsnfg.com

Packing Slip

Packing Slip No.:

48106

Date:

05/12/2017

Page:

1

Sold to:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO K6A 1K7

Ship to:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO K6A 1K7

Order No.: 35991

Sold By: LOWEY, ARLA

Shipped By:

Ship Date: 05/12/2017

Tracking No.:

Item No.	Unit	Description	Quantity	Backorder quantity
D2646P ✓	Each	Aft CAp	50	
SPH - \$19.				

Comment:

DAS

36

9-89

DQA: _____ Date: _____

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